

Work Order ID 84112

84112

Page 1

May-03-12 11:24:53 AM

Item ID: D3198-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fitting
 Start Date: 03/05/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 17/05/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/03 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3198	Rev A

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00 12 0 Jm
 FLOW CNC Waterjet 1-Cut as per Dwg D3198 Dwg Rev: 1A Prog Rev: 1A 2- 12-5-23
 Deburr if necessary 304 .125

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00 12 0 Jm
 Quality Control 12-5-23

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00 12 0 WJ 12 05 23
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3198-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Fitting

Stop

NS2

Start Date: 03/05/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 17/05/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE					12			SB 12/05/28
Brake NC	Memo	0.00							
Brake NC	1-Deburr if necessary 2-Form as per Dwg D3198								
140		0.00							
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				412			8 12/05/28
Quality Control									
150		0.00							
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:00 OVEN TEMPERATURE:								
	FINISH TIME: 3200 F 11:30								

m 121279

12X ✓ 12/05/30 m/l

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3198-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fitting
 Start Date: 03/05/2012 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 17/05/2012 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>ST 246A</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12x 6 MU 12/05/30

MF 12-05-30

12/5/30

MF 12-05-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84112

84112

Parent Item: D3198-1

D3198-1

Parent Item Name: Fitting

Start Date: 03/05/2012

Required Date: 17/05/2012

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP: A03.11.11New IssueKJ/RF

IPP Rev:B Now on Waterjet 07-01-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	38.2900	0.105	1.326316			

M304S11GA

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

38.29

121070

3.69

121380

34.6

121780

121780

Jm
12-5-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

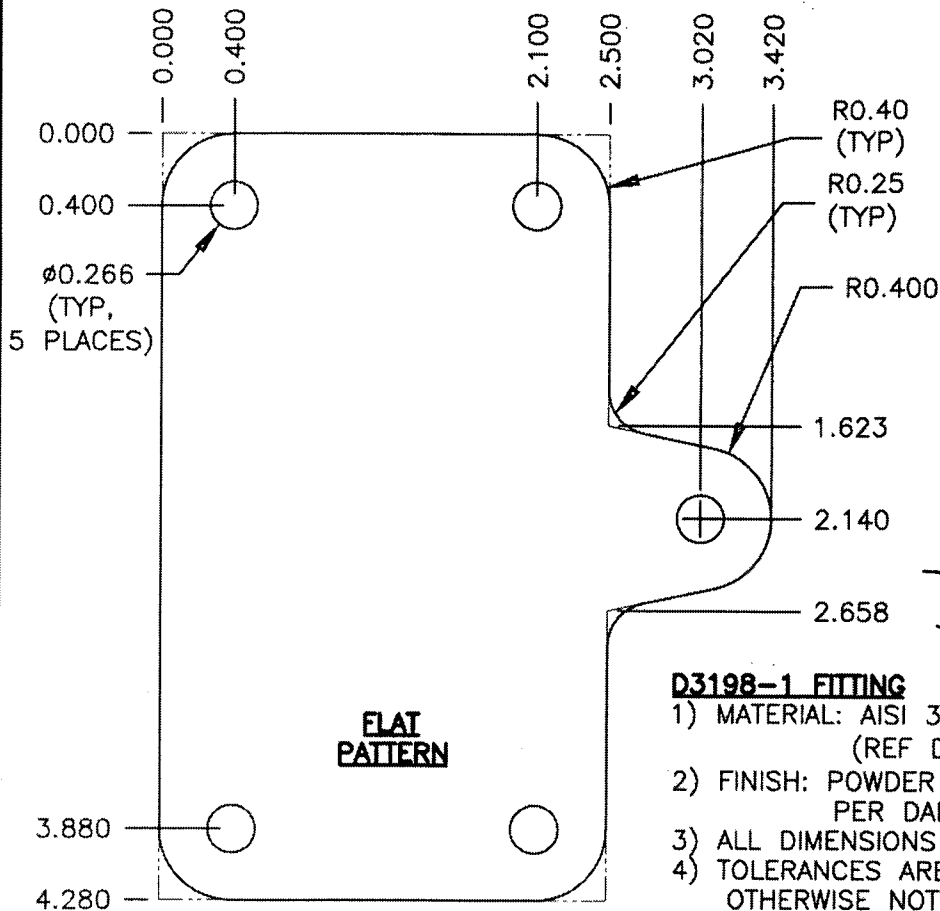
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3198	REV. A SHEET 1 OF 1
DATE 03.09.26		TITLE FITTING	SCALE 1:1
A	03.09.26	NEW ISSUE	

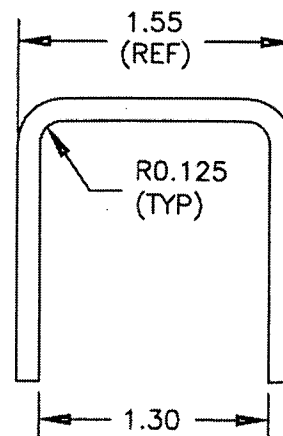
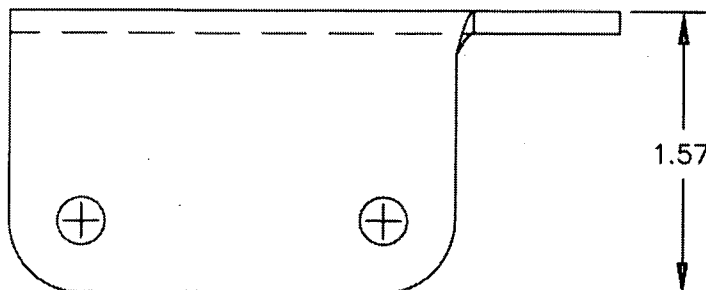


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84112 MJS
12/05/03

D3198-1 FITTING

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK
(REF DART SPEC. M304S11GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

RELEASED
03.10.10



**BEND
DETAIL**

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